

Work Order ID 148562

Tuesday, July 05, 2016 3:06:30 PM

148562

Page 1

Item ID: 650.9201

Revision ID:

Item Name: Eyelet Bracket Assembly

Start Date: 6/17/2016 Start Qty: 6.00

Required Date: 7/14/2016 Req'd Qty: 6.00

Reference:

650.9201
B148562
REV. A1

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals:

Process Plan: DAS 21

Date: JUL 12 2016

Tooling:

Date:

Run Start *NR1*

QC: 9-89

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
650.9200	A1								
100	BAND SAW	0.00							DAS 08 9-89
100									
Bandsaw	Memo	0.00							
Jeaspa Bandsaw	Cut Blank at 2.200"								
110	HAAS CNC VERTICAL MACHINING #1	0.00							DAS 20 9-89 16-07-22
110									
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	1-Machine per folio FB361 DWG REV: A FOLIO REV: AA								
	2- deburr and break all sharp edges								

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																															
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130	QC8- Inspect parts - second check	0.00	
130			DAS 44 9-89 <u> </u> <u> </u> <u> </u> <u>16-02-22</u>
QC	Memo	0.00	
Quality Control			

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Work Order ID 148562

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148562

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Item ID: 650.9201 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Eyelet Bracket Assembly
Start Date: 6/17/2016 Start Qty: 6.00 ***6*** Cust Item ID:
Required Date: 7/14/2016 Req'd Qty: 6.00 ***6*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Outsource process-Anodize per QSI017 4.1.10.1	0.00							
140									
Outsource4	Memo	0.00							
Outsource process - Anodize	Issue P/O to ATG : <u>33188</u>								
	1- Black Anodize as per Dwg 650.9200								
	2- PRIME AS PER DWG, SEE NOTE #3****MASK THREADS ON BOTH SIDE BEFORE PRIMING****								
	Certification of Comformity is required								
150	Receive & Inspect for Damage & Mat'l Certs	0.00							
150									
Packaging	Memo	0.00							
Packaging									

6-07286x SP16-8-12

DQA: _____ Date: _____



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																						OTHER :																																									

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IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV

DQA: _____ Date: _____



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SEP 07 2016

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OTHER : _____									

Picklist Print

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Work Order ID: 148562

148562

Parent Item: 650.9201

650.9201

Parent Item Name: Eyelet Bracket Assembly

Start Date: 6/17/2016

Required Date: 7/14/2016

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP REV:A NEW ISSUE 15-01-08 JLKM VERIFIED BY:DD IPP
REV:B AS PER DWG A1 15.09.14 DD VERIFIED BY:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M7075T6B1.000x2.500

Purchased

No

f

7.8700

1.117895

M7075T6B1 000x2 500

7075-T6 Bar 1.000 x 2.500"

1.125 16/07/17

DAS
08
9-8"

Location

Loc Qty

Loc Code

MAT

7.87

→ m133929

7.87

1.125 FF

MS21209F5-15

Purchased

No

Each

10.0000

6

MS21209F5-15

Heli Coil

135536X3 FF AUG 16 2016

3 20/8/16

Location

Loc Qty

Loc Code

ST296

10

m134294

10

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
							Completed By		
							Lead hand / Supervisor Approval Verification		
							QC / QA Coordinator Approval		

Root Cause			FAULT CATEGORY					
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐			
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐			
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐			
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐			
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐			
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐			
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐			
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐			
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐			
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐			
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____						
Misidentified ☐	Past Due ☐							



APICAL INDUSTRIES, INC.
dba DART AEROSPACE

TRANSACTION CODES (TC):
A-ADD C-CREATE
R-REVISE D-DELETE

ENGINEERING CHANGE NOTICE NO.

04960

SHEET 1 OF 1

DWG NO. 650.9200

REV: A

PREPARED BY J. SOTO

DATE: 05/13/2015

EFFECT ON DWG
☐ INC. ☒ UNINC.

DWG TITLE: EYELET BRACKET ASSY

APPROVED BY: ENGR

MFG

QC

EFF. NEXT ORDER

REASON: REVISED F/N 2.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 148562 MLJ
10-07-12

PRINTED COPY OF THIS DOCUMENT IS FOR REFERENCE ONLY AND IS UNCONTROLLED

2	R	601.3806	1	HELICAL INSERT	MS21209F5-15	
F/N	TC	PART NUMBER	QTY	DESCRIPTION	MATERIAL	SPECIFICATION
DOCUMENTS EFFECTED:				CHANGE CATEGORY	DER REVIEW REQUIRED	
☐ PATTERN ☐ MDL ☐ INSTALL INSTRUCTIONS ☐ ICA ☐ FMS ☒ BOM				☐ MAJOR ☒ MINOR	☐ YES ☒ NO	

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REV	DESCRIPTION	DATE	APPROVED
NC	INITIAL RELEASE	11-19-14	P. BRAVO
A	INCORPORATED ECN 6460 & 6474	04-20-15	P. BRAVO

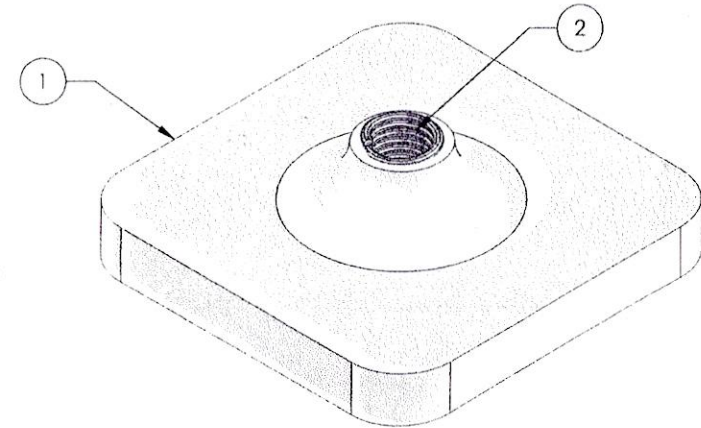
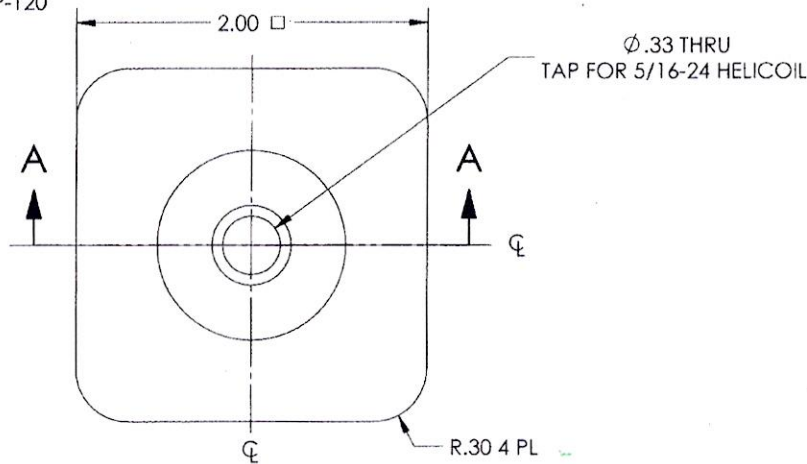
1 PART DIMENSION CONTROLLED BY 3D CAD MODEL
F/N 1 CONTROLLED BY "650.9210 EYELET BRACKET.SLDPRT".
LAST MODIFIED: 11-17-14

2 MATERIAL: ALUMINUM 7075-T651 PER AMS-QQ-A-250/12

3 FINISH: IAW MPP-172 ANODIZE IAW SECTION 2.1,
PRETREATMENT IAW SECTION 3.2,
PRIMER IAW SECTION 4.3.

4. BREAK AND DEBURR ALL SHARP EDGES

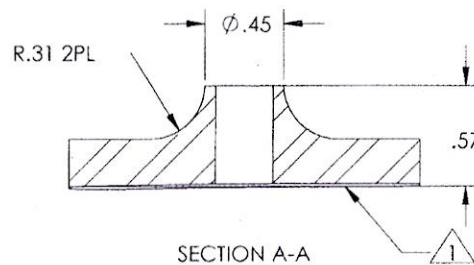
5. IDENTIFY IAW MPP-120



650.9201

UNINCORPORATED ECN(s)

049160



	1	2	601.2746	HELICAL INSERT	MS21209F3-20	
	1	1	650.9210	EYELET BRACKET	 	
			650.9201	EYELET BRACKET ASSY		
		FIND #	PART #	DESCRIPTION	MATL	SPEC.
BOM Table						
QTY	PARTS LIST					
NEXT ASSY (S)	ORIGINAL DATE	11-19-14	 3030 ENTERPRISE CT. SUITE A VISTA, CA 92081 (760) 724-5300 APICAL INDUSTRIES, INC. (800) DART #100SPACE			
646.4000	DRAWN BY	P. BRAVO				
	DESIGNED BY	P. BRAVO				
	CONTRACT NO.					
	UNLESS OTHERWISE SPECIFIED	DIMENSIONS ARE IN INCHES DECIMALS ARE 2 PLACE DECIMALS ±.005 3 PLACE DECIMALS ±.001 ANGLES ± .5°				
	SIZE	CAGE CODE	DWG. NO.	REV		
	B	07M26	650.9200	A		
	SCALE	NONE	SHEET	1 OF 1		



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO33188

Purchase Order Date 7/28/2016

PO Print Date 8/3/2016

Page Number 2 of 4

Order From :

A.T.G. INDUSTRIES INC.
731 INDUSTRIELLE ROAD
ROCKLAND, ON K4K 1T2
CANADA

VC-ATG001

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone 613-446-4544

Ship To Contact

Ship To Phone

Ship Via: VENDOR'S TRUCK

Ship Acct:

Buyer

Customer POID

Customer Tax # 10127-2607

Terms Net 30

Currency CAD

FOB FCA - (Free Carrier)

Line Total: \$121.00

4	145327	647.4112	8/5/2016	11.00	\$7.00	\$77.00
			Yes			
			8/5/2016			

FINISH: HARD BLACK ANODIZE AS PER IAW MIL-A-8625 TYPE III, CLASS 2 / PRIME AS PER IAW MIL-P-23377J TYPE 1 CLASS N

Line Total: \$77.00

5	145488	647.4113	8/5/2016	12.00	\$7.00	\$84.00
			Yes			
			8/5/2016			

FINISH: HARD BLACK ANODIZE AS PER IAW MIL-A-8625 TYPE III, CLASS 2 / PRIME AS PER IAW MIL-P-23377J TYPE 1 CLASS N

Line Total: \$84.00

6	148562	650.9201	8/5/2016	6.00	\$6.60	\$39.60
			Yes			
			8/5/2016			

FINISH: HARD BLACK ANODIZE AS PER IAW MIL-A-8625 TYPE III, CLASS 2 / PRIME AS PER IAW MIL-P-23377J TYPE 1 CLASS N

Line Total: \$39.60

SP/6-8-12

Note:

8/3/2016



A.T.G. INDUSTRIES INC.
731 INDUSTRIELLE STREET
ROCKLAND, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 912097

Date: 11-Aug-16

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

CHANTAL LAVOIE
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
Quantity	Description		
	PLEASE REFERENCE THE PACK LIST NUMBER ON ALL CORRESPONDENCE TO THIS SHIPMENT. IF YOU HAVE ANY QUESTIONS, PLEASE CALL AT (613) 446-4544.		
12 ea	Part: 647.0110 Job: 19921	PO: PO33188	Rev: Line: 1
10 ea	Part: 646.9910 Job: 19922	PO: PO33188	Rev: Line: 2
4 ea	Part: 647.1710 Job: 19923	PO: PO33188	Rev: Line: 3
11 ea	Part: 647.4112 Job: 19924	PO: PO33188	Rev: Line: 4
12 ea	Part: 647.4113 Job: 19925	PO: PO33188	Rev: Line: 5
6 ea	Part: 650.9201 Job: 19926	PO: PO33188	Rev: Line: 6
5 ea	Part: 647.1712 Job: 19927	PO: PO33188	Rev: Line: 7
1 ea	Part: ADMINISTRATION FEE ADMINISTRATION FEE Job: 19928	PO: PO33188	Rev: N/A Line: 9



A.T.G. INDUSTRIES INC.
731 INDUSTRIELLE STREET
ROCKLAND, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 912097

Date: 11-Aug-16

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

CHANTAL LAVOIE
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms

Ship Via

Quantity

Description

DATE: 11/08/16

CERTIFIED SIGNATURE: [Signature]

RECEIVER SIGNATURE: SP16-8-12

Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt.

CERTIFICATE OF CONFORMANCE

A.T.G. INDUSTRIES INC. CERTIFIES THAT ALL ITEMS IN THIS SHIPMENT CONFORM TO REQUIREMENTS.

MADE IN CANADA.